

Date: Wednesday, 1/25/2006 1:16:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP		
Job Number	: 25611					
Estimate Number	: 10267					
P.O. Number	: N/A		Part Number	: D2438		
This Issue	: 1/25/2006	S.O. No. : N/A	Drawing Number	: D2438 REV. C		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: C		
Previous Run	: 25015		Material	: N/A		
Written By	: See COMMENT BELOW		Due Date	: 2/15/2006		Qty: 200 Um: Each
Checked & Approved By	: DJ 06.01.25					
Comment	: Est: E 05.06.28 Bending removed KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	 <i>AK 06/01/27</i>
		Comment: PURCHASING Issue P/O: 00000455 Laser cut as per Dwg D2438 Material release note is required	
2.0	D2438B	Clamp	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s) CLAMP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	<i>1/6/16 200</i>
4.0	QC6	DIMENSIONAL CHECK	 <i>Jan 17</i>
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2438 (6.786" center to center)	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	 <i>DL 06/02/25 200</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr any rough edges	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 25611

Part Number: D2438

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



06/22/25

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST178

06/22/25

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/22/25

Job Completion



06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

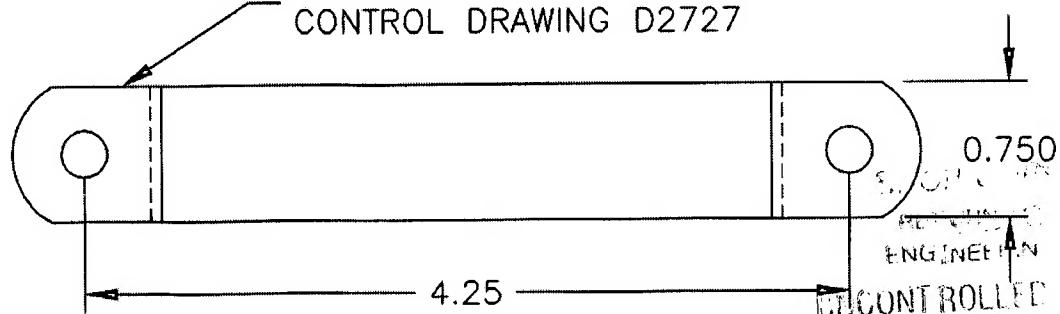
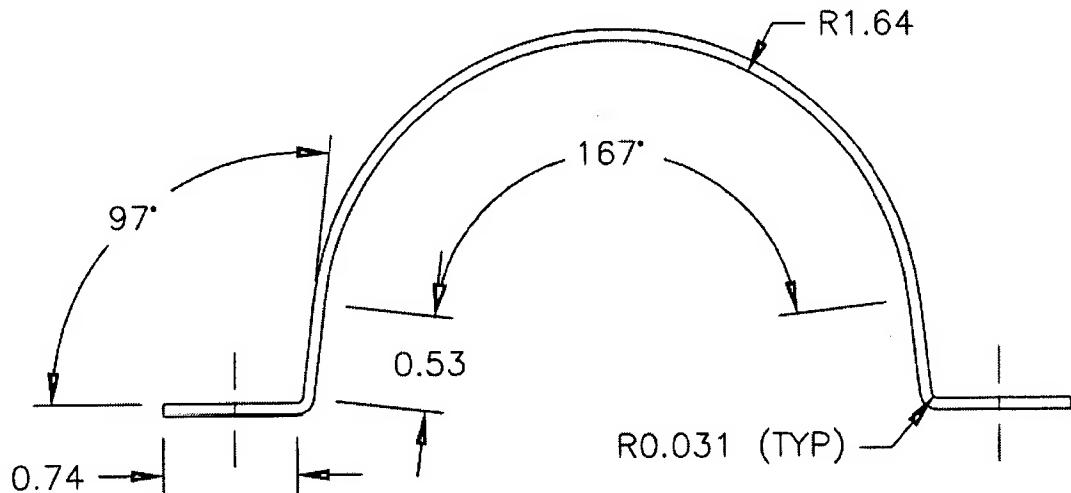
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>CD</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE

FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

NO 25611

06.06
GP 06.07

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 5 OUR JOB NO. J0138792 SHIPPING MEMO 0330870

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	<u>200 PCS</u>	<u>P000000455</u>	<u>D2438</u>	<u>C</u>	<u>CLAMP</u>	<u>C</u>
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
<u>S.S.T 304</u>		<u>SAMUEL SPECIALTY/ AK STEEL</u>			<u>7341615 ATT'D</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 14 FEBRUARY 2006

G.F.I. Q.C. REP.

06/02/17



**LES MÉTAUX
SPÉCIALISÉS**
SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100.

LETTRE DE CONFORMITÉ -LETTER OF COMPLIANCE

Date: 1 AOÛT 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0066654

de commande SSMQ: 843000

Customer's order #:

SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	10	.060" X 48" X 96"	304 2B		7341615

Bien à vous,
Yours truly,

José Raymond

Commis à l'administration.
Administration Clerk.

06.02.17



		AK Steel Corporation Metallurgical Test Report Rockport Works Rockport, IN 47635						Page 1 Load No. 7288793 SRN No. 7288793						
CUSTOMER	SAMUEL & FILS & CIE LTÉE (S) PUK DEPT 2225 FRANCIS HUGHES DRIVE LAVAL, CN H7SIN-5		S SAMUEL & FILS (QUEBEC) LTÉE H 2225 FRANCIS HUGHES P LAVAL, CN H7SIN-5						MILL ORDER NO.	PROCESSOR ORDER NO.				
									252502-0523	C97428-1				
								BUYERS ORDER NO.	PART NO.					
								C97428-1						
COIL ID	HEAT	PARENT COIL ID	WEIGHT			ENGLISH UNITS			PRODUCT SIZE			METRIC UNITS		
503431-05BA	734161S	0503431-05B	13,140 LBS. 5,960 KG.			.0590 NOM 48.0000 X COIL								
503431-05BB	734161S	0503431-05B	13,050 LBS. 5,919 KG.			.0590 NOM 48.0000 X COIL								
503431-05BC	734161S	0503431-05B	13,130 LBS. 5,936 KG.			.0590 NOM 48.0000 X COIL								
L-List Analysis of Heat P-Product Analysis of Parent Coil			CHEMICAL ANALYSIS											
ID	C	MN	P	S	SI	CR	NI	MO	N	CU				
L 734161S	.052	1.385	.032	.0011	.342	16.18	8.10	.35	.0390	.37				
SHIPPING DATE: 02/16/2005			REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL. MATERIAL FREE OF RADIOACTIVE ISOTOPES											
PRODUCT DESCRIPTION														
CR SHOT TYPE 304 STAINLESS #2B FINISH SLIT EDGE TEST REPORTS * ASTM A 240 -04 EX PARA 3.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 * * ASTM A 480 -01 EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASME SA-240 SECTION II PART A (2001 ED. 2002 ADDENDA) EX PARA 3.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 * ASME SA-480 SECTION II PART A (2001 ED) EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASTM A 262 -01 PRACTICE E * ASTM A 666 -00 EX 6.1.9 ELONG WILL BE DETERMINED BY ASTM E 8, EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVERSE TEST DIRECTION IN ALL CASES														
PARENT COIL ID	POS (S/T)	DIR (L, T, B)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. 2% OFFSET (KSI)	ROCKWELL HARDNESS Fall	ROCKWELL HARDNESS Front						
0503431-05B	T	T	A.S.I.M	58.2	94.7	47.1	B 85.3	B 85.9						

*** CONTINUED ON NEXT PAGE ***

2/17
04/05 b52/17
04/05 b5
02/10

				AK Steel Corporation Metallurgical Test Report Rockport Works Rockport, IN 47635				Page 2 Load No. 7288793 SRN No. 7288793				
C S T O M E R	SAMUEL & FILS & CIE LTEE (S)			SAMUEL & FILES (QUEBEC) LTEE			MILL ORDER NO.			PROCESSOR ORDER NO.		
	PUR DEPT 2225 FRANCIS HUGHES DRIVE LAVAL, CN H7S1N-5			2225 FRANCIS HUGHES LAVAL, CN H7S1N-5			252502-0523			C97428-1		
P A R E N T C O I L	ID 6503431-05B	POS T	DIR (P/T) L, T, D	COND A.S.T.M. PASS	ASTM A 262 PRACTICE E	BEND 180 IT OK	BUYERS ORDER NO.			PART NO.		
							C97428-1					
<p>THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT AS CONTAINED IN THE RECORDS OF THIS CORPORATION.</p> <p>ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED</p> <p>AK Steel Corporation</p> <p>MWCG#0049 3/99</p> <p>SIGNED </p> <p>DATE 02/17/2005 TIME 0923 AM</p> <p>QUALITY MANAGER</p>												

FEU-17-2005 06:45

FAX: AK Steel 1 RightFax

PAGES: 002 R=22x